

# Work Order ID 84481

**\*84481\***

Page 1

May-15-12 1:06:23 PM

Item ID: D206-642-412 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 5/14/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan:                      Date:              Tooling:              Date:              Run Start **\*NR1\***  
 QC:                      Date:              SPC (Y/N):              Date:              Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	O								

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-4129-01G006

DAS  
16  
17/07/12

# Work Order ID 84481

\*84481\*

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Item ID: D206-642-412 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 5/14/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

101		0.00							
*101*									
HandFinish		0.00							
Hand Finishing									

Memo  
 PULL FROM HK:  
 1 X D206-642-411 B34060 -CHG 004  
 UPDATE TO CHG006 PER ECN08-538 & 09-531 DSI9421/9440

REMOVE WEARPLATES:  
 6 X D2648-3 B32465  
 1 X D2656-15 B34170  
 1 X D2656-23 B32580  
 1 X D2656-37 B32017  
 1 X D3429-1 B34012  
 RETURN TO STK  
 DISCARD HARDWARE

ADD:  
 6 X D3537-1 B \_\_\_\_\_  
 1 X D3537-3 B \_\_\_\_\_  
 1 X D3535-15 B \_\_\_\_\_  
 1 X D3536-15 B \_\_\_\_\_  
 1 X D3535-23 B \_\_\_\_\_  
 1 X D3536-23 B \_\_\_\_\_  
 1 X D3535-37 B \_\_\_\_\_  
 1 X D3536-37 B \_\_\_\_\_  
 60 X MS27039C1-08 B \_\_\_\_\_  
 60 X AN960C10L (NAS1149C0332R)  
 B \_\_\_\_\_

<b>DART</b>		TEL: 1-613-632-3336 FAX: 1-613-632-4449	
TRANSPORT CANADA APPROVAL # 09-69			
PN	D206-642-412	CHG	CHG004
DESC	Skidtube RH High	STC	SH98-4
LOT	B34060	STC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	STC	
US PATENT # 6735484 CANADA/FOREIGN PATENTS PENDING		MADE IN CANADA	

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**\*84481\***

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Item ID: D206-642-412

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 5/14/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

**\*105\***

QC

Memo

0.00

Quality Control

S. Lalala

# Work Order ID 84481

\*84481\*

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Item ID: D206-642-412 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 5/14/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Pick Kit	0.00							
*110*									
Packaging									
Packaging									
	Memo	0.00							
	REMOVE FROM KIT TO UPDATE TO CHG006:								
	1 X D2707-043(OR D2968-043)-SCRAP								
	1 X AN960JD1016 B								
	1 X AN970-4 B								
	1 X MS210424 B								
	1 X AN4-5A B								
	1 X AN960JD416 B								
	1 X D2655 B								
	RETURN TO STK								
	ADD TO KIT:								
	1 X D3407-043 B								
	1 X D3456-1 B								
	2 X D3457-1 B								
	1 X MS21043-4 B								
	1 X AN4C5A B								
	1 X AN960C416 B								
	1 X D3413-1 B								

12/6/12

SS 192  
 30275  
 104285  
 104746  
 100657  
 104746  
 32280

## Page 5

0.00

(DAS  
96  
8-82 7/2/10

(12/7/81)

12/7/2019  
mf  
12-07-19

# Picklist Print

May-15-12 1:06:22 PM

Page 1

Work Order ID: 84481

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.10.11 Revised picklist per CHG004KJ/CP/JLM  
IPP Rev:L 07-12-05 ECN 1080p DD verified by:ec  
IPP Rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
AN4C5A BOLT		Purchased	No				Each	199.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1			
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	30.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

D2968-643 B 30275

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Work Order ID: 84481  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No Each 203.0000  
Washer

-1

*M/10/8/55*

Location	Loc Qty	Loc Code
ST344	203	
115936	11	
120308	3	
120644	30	
121285	159	

D206-642-412 Manufactured No Each 2.0000  
Skidtube RH

1

*B84481*

Location	Loc Qty	Loc Code
FG081	1	
78487	1	
FG082	1	
41319	1	

D2648-3 Manufactured No Each 9.0000  
Wearpad

-6

*B/1265*

Location	Loc Qty	Loc Code
ST <i>32465</i>	-10	
81513	9	
ST237A	19	

6

D2655 Manufactured No Each 30.0000  
Ring

-1

*B. 32080*  
*12/6/7*

Location	Loc Qty	Loc Code
ST464	30	
44295	15	
45738	15	

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Work Order ID: 84481

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D2656-15 Manufactured No Each 6.0000  
Wearshoe

-1

BR 1265

Location	Loc Qty	Loc Code
FP 34170	5	
83601	5	
Mezz	1	
51455	1	

1  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

D2656-23 Manufactured No Each 9.0000  
Wearshoe

-1

BR 1265

Location	Loc Qty	Loc Code
Mezz 32580	9	
43407	2	
51468	7	

1  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

D2656-37

D2656-23 Manufactured No Each 9.0000  
Wearshoe

-1

BR 1265

Location	Loc Qty	Loc Code
Mezz	9	
43407	2	
51468	7	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

D3407-043 Manufactured No Each 14.0000  
Tow Ring

1

B 8691951

Location	Loc Qty	Loc Code
ST420	1	
79232	1	
ST463	13	
68339	2	
77504	10	
78841	1	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

12/2/18



# Picklist Print

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Work Order ID: 84481

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

B3413-1  
Ring

Manufactured No

Each 73.0000

1

Location

Loc Qty

Loc Code

ST420

4

79233

4

ST464

69

76754

1

80224

7

83307

41

83867

20

D3429-1  
Wearpad

Manufactured No

Each 16.0000

-1

Location

Loc Qty

Loc Code

FP002

16

40438

2

43706

1

44579

12

65692

1

D3456-1  
Washer

Manufactured No

Each 168.0000

1

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

161

80252

1

81876

60

83584

100

# Picklist Print

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Work Order ID: 84481  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3457-1 Manufactured No Each 35.0000  
Washer

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST044	25	
67779	1	
81977	24	

B83268 D

D3535-15 Manufactured No Each 17.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	17	
80328	4	
81354	13	

1 BR 12-6-5

D3535-23 Manufactured No Each 22.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	22	
81355	2	
83375	20	

1 BR 12-6-5

D3535-37 Manufactured No Each 4.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	4	
84827	4	
71668	4	

1 BR 12-6-5

D3536-15 Manufactured No Each 20.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	20	
73318	14	
81343	6	

1 BR 12-6-5

# Picklist Print

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Work Order ID: 84481

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No Each 16.0000 1 BR 12-6-5  
Gasket

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377 ✓	15	

D3536-37 Manufactured No Each 19.0000 1  
Gasket

Location	Loc Qty	Loc Code
FP002	19	
66823	7	
82623 ✓	12	

D3537-1 Manufactured No Each 41.0000 6 BR 12-6-5  
Wearpad

Location	Loc Qty	Loc Code
FG 84091	10	
79833	10	
FP002	31	
69817	5	
81362	22	
83254	1	
83255	3	

D3537-3 Manufactured No Each 28.0000 1 BR 12-6-5  
Wearpad

Location	Loc Qty	Loc Code
FP002	28	
78836	5	
81363 ✓	23	

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Shop Packet Print

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# Picklist Print

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Work Order ID: 84481

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21042-4  
USE MS21042L4

Purchased No Each 1,071.0000

-1

M104248

Location	Loc Qty	Loc Code
ST299	1071	
100743	9	
119124	1000	
5461	1	
6844	19	
7690	24	
8182	6	
9063	8	
9229	4	

MS21043-4  
Nut

Purchased No Each 1,546.0000

1

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1506	
119546	185	
121162	821	
121652	500	

MS27039C1-08  
SCREW

Purchased No Each 1,142.0000

60

BR 12-0-5,

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308	354	
121068	108	
121162 ✓	660	
ST293	19	
116373	3	
118077	14	
119309	2	

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Shop Packet Print

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# Picklist Print

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Work Order ID: 84481

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

3,354.0000

60

*BL 12-6-5.*

Washer

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

3135

121255

11

121509 ✓

3124

*60 60.*

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Shop Packet Print

Page 8

37

Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE  
Job-Number : 34060A  
Estimate Number : 10522  
P.O. Number : N/A Part Number : D206642441  
This Issue : 17/08/2007 S.O. No. : N/A Drawing Number : D2650 REV E  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : LANDING GEAR Drawing Revision : E  
Previous Run : 34059A Material : N/A  
Written By : Due Date : 12/09/2007 Qty: 1 Um: Each  
Checked & Approved By : 07.08.20  
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002 N/A 07.08.20

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

\* Qty Part Number Description Batch  
1 D2620 Bent Tube 3" OD 33880 BE 07-09-04

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2647 Fwd Cap 22228 BE 07-09-04

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M104221/M105058

4-Grind weld flush to cap on top surface only.

BE 07-09-04

Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34060A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297"

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

DP  
7-9-6

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DP 7-9-6

6.0

D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B-31169

AWM  
07/09/06

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 07/09/06 Time: 3:19

Finish Date: 07/09/06 Time: 05:46

A/R Sikaflex-291

Sikaflex expiry date: 08/01/01

AWM  
07/09/06  
7-9-6

Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34060A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*EP 07-09-10*

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

*B33214 BE 07-09-11*

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod *m 104221 BE 07-09-11*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

*DP 7-9-12*

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

*B30446 DP 7-9-12*

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

*103525 DP 7-9-12*



Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34060A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

102515

DP 7-9-12

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

DP 7-9-12

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/13

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/13

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

m.k 07/09/17

(IX)

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

M105068

m.k 07/09/17

(IX)

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/09/17 (1)

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

BS2465

FL 07/09/17 (1)

Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34060A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B34170

FL

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B32580

FL

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B32017

FL

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B34012

FL

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

m102475

or (see QSI 017)

FL 07/09/17 ①

Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34060A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

*m 104885*

*FL*

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

*m 105433*

*FL*

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

*B32576*

*FL*

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

*B34186*

*FL*

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

*m 103338*

*FL 07/09/17*

*(1)*

Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34060A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06 Screw

*m15194*

*FL*

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646 Aft Cap

*B31335*

*FL*

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L Washer

*m104885*

*FL*

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08 Screw

*m105433*

*FL 07/09/17 ①*

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

*m104989 m105469*  
*08-01*

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

*FL 07/09/17 ①*

Date: Friday, 17/08/2007 11:19:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34060A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

M105469  
08-01

> FL 07/09/17 ①

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4'

Batch: M105386

07-09-18 ①

36.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/19

37.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/19

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RRP 34060 07/09/19 ①

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/20 ①

Job Completion



07/09/20

Part Number D206-642-412  
Description 206 SKIDTUBE INSTALLATION

Chg.	Date	By	Relevant Documents
1	98.12.14	DS	MDL - D206-642 REV. I
2	99.04.28	DS	- MDL - D206-642 REV. J - ADDED SHOULDER SPACERS PER DSI 9150 REV. A - D2655 TOW RING SHIPPED LOOSE RATHER THAN INSTALLED ON SKID TUBE
3	00.03.14	DS	CHANGE TO D2968-043 TOW RING PER DSI 9181 REV. A
4	05.10.05	CP	Add 1)3474-1 MDL - D206-642 REV D
005	08.10.07	HA	DSI 9421 Rev. A, D2650 Rev. F (ECN 08-538)
006	09.02.19	HA	D319421 Rev. B, DSI 9440 Rev. A D206-648 Rev. B, D3474 Rev. B (ECN 09-5

✓ 84478 - 39120

~ 84479 - 34564

✓ 84480 - 34562

84481 - 340100

# **ENGINEERING CHANGE NOTICE** **DART AEROSPACE LTD**

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: <i>[Signature]</i>		
Product Name: Skidbe Installation	Checked By: <i>[Signature]</i>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>[Signature]</i> 09.02.19
Production Engineering Coord	Y	EC/DD	<i>[Signature]</i> 09.02.19
Production Document Control	Y	JLD	<i>[Signature]</i> 09.02.19
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	<i>[Signature]</i> 09.02.19
Marketing	Y	SW	<i>[Signature]</i> 09.03.19
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

## **Documents Affected:**

DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

PARTS MUST COMPLY

☐

PREVIOUS PARTS SATISFACTORY

☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19 <i>[Signature]</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Moye Electronic Files	Y	KJ		09.02.19 <i>[Signature]</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19 <i>[Signature]</i>
10	Update Controlled PDF Files	Y	KJ		09.02.19 <i>[Signature]</i>
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19 <i>[Signature]</i>
12	Update Document Record (DR)	Y	KJ		09.02.19 <i>[Signature]</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19 <i>[Signature]</i>
18	Create / Update PPP's	Y	KJ		09.02.19 <i>[Signature]</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19 <i>[Signature]</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19 <i>[Signature]</i>
22					
23					

## **Description / Action:**

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)

-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)

Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)

-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)

Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) - DO NOT MIX PARTS

ECN Verified & Complete: *[Signature]*

Date: 09/03/16

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: [Signature]		
Product Name: Skidbe Installation	Checked By: [Signature]	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date	Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL		DQA / QA Coord			
Production Engineering Coord	Y	EC/DD	11/09/02/19	QC Coordinator	Y	JM	09.02.19
Production Document Control	Y	JLD	09.02.19	Marketing	Y	SW	
Customer Technical Support				Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:  
DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

PARTS MUST COMPLY ☐

PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

**Description / Action:**  
Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)  
-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev.A)  
Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)  
-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev.A)  
Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005  
  
Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006  
D206-648-011/-013 NOW AT CHG002 (D206-648 Rev.B) -DO NOT MIX PARTS  
  
N/A  
JW 09.03.03

ECN Verified & Complete: \_\_\_\_\_

Date: \_\_\_\_\_



4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	08.10.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skid tubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>MA</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>MA</del>	TITLE	SCALE
DE APPR.	<del>MA</del>	WEARSHOE CHANGE	NTS
DATE	09.03.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

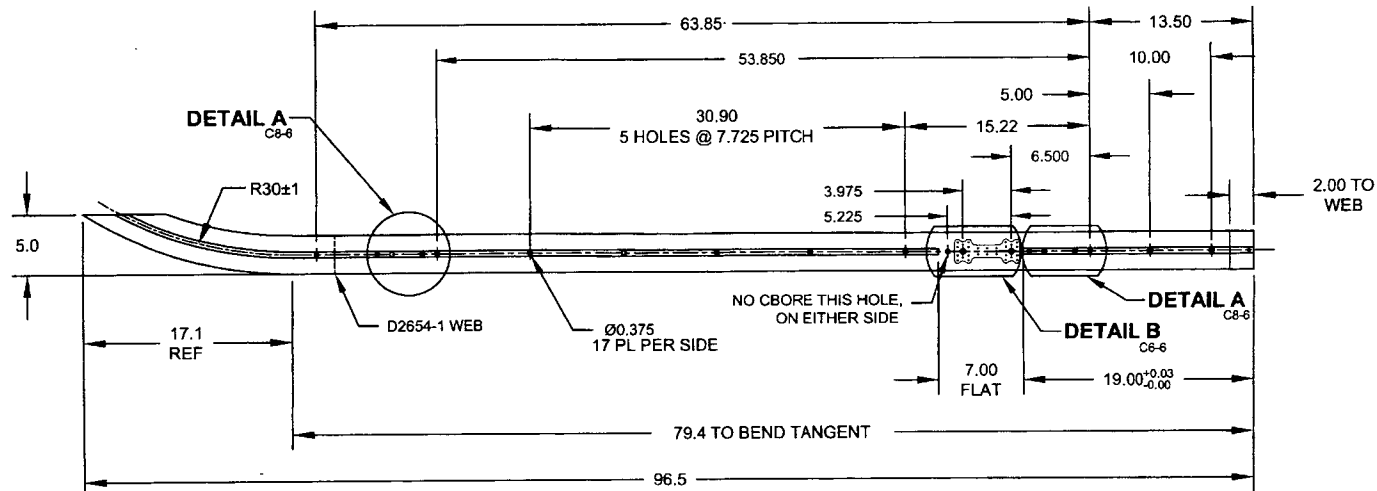
8/1/81

RELEASED  
08-23-17

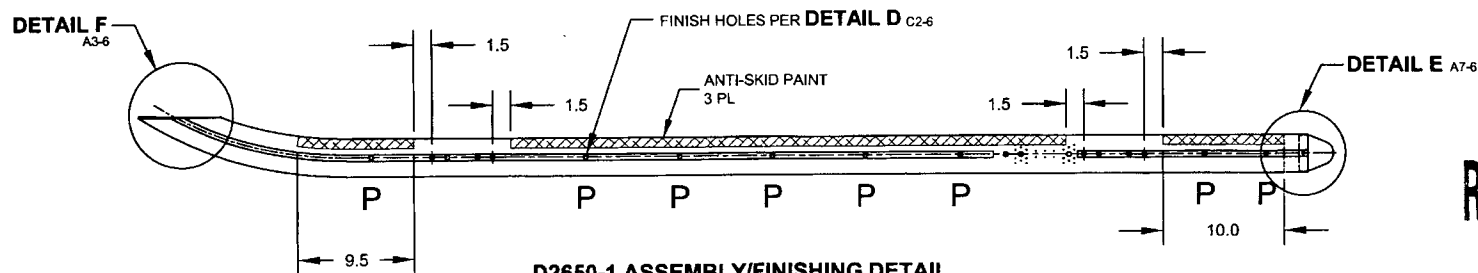
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	



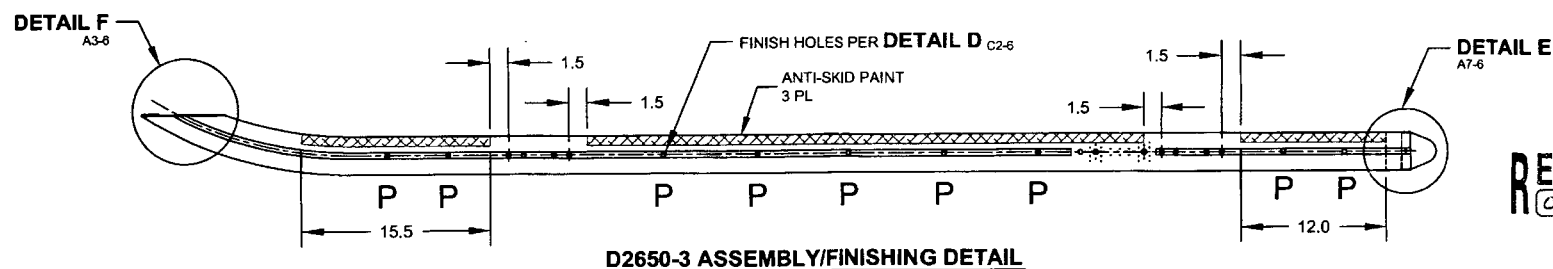
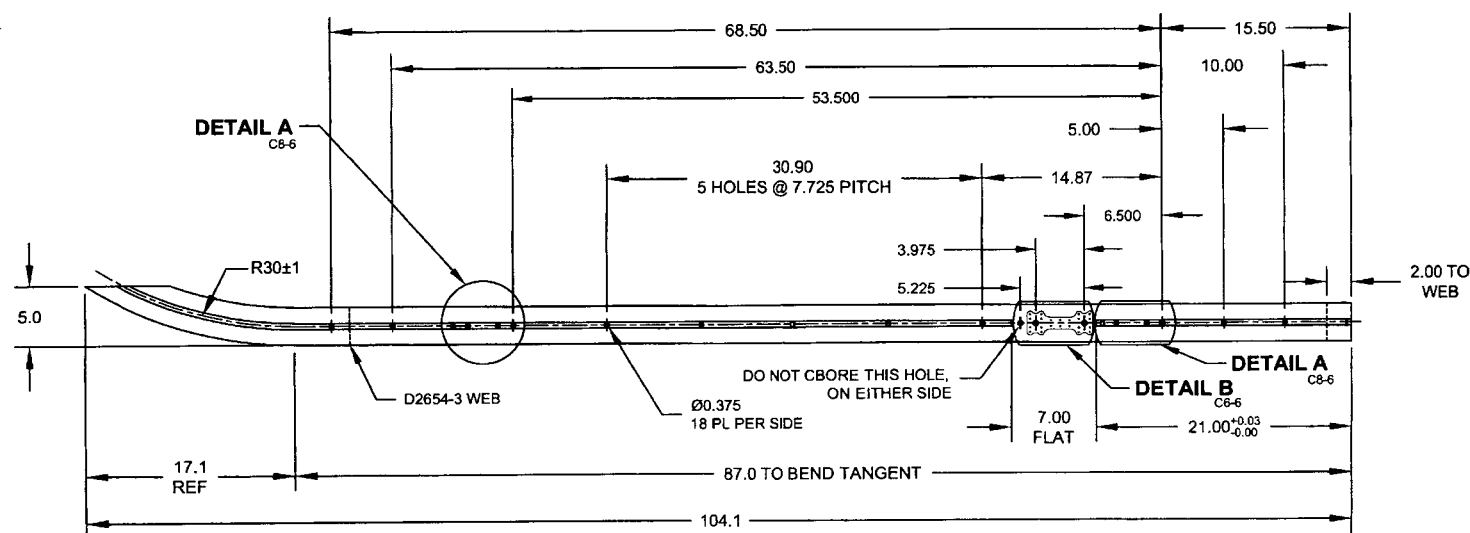
**D2650-1 BENDING/DRILLING DETAIL**



**D2650-1 ASSEMBLY/FINISHING DETAIL**

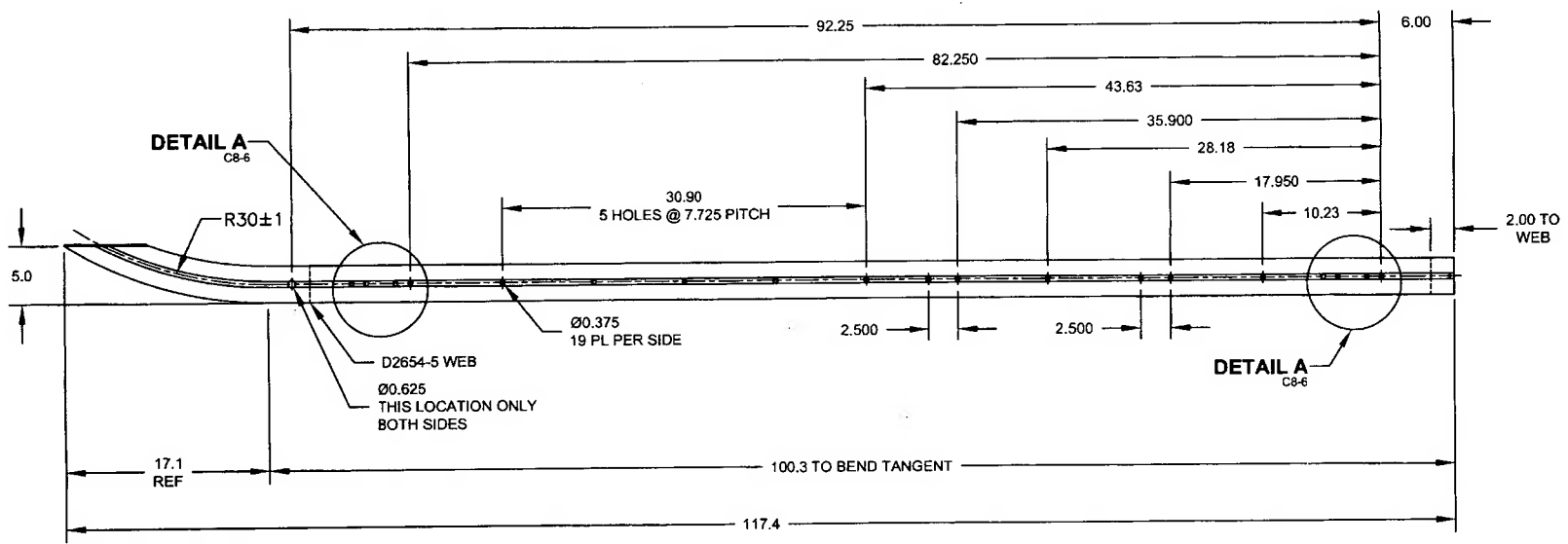
**RELEASED**  
82 09 22 / 111

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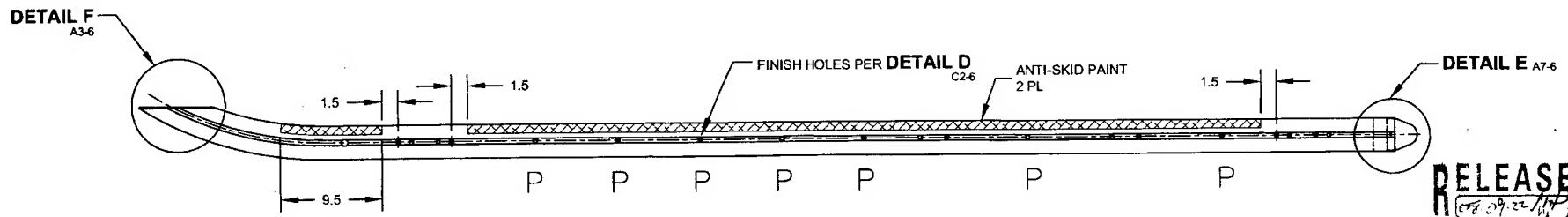


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08 07 22 1100

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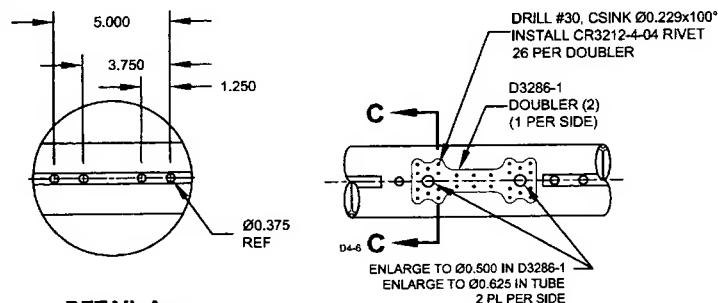
**D2650-5 BENDING/DRILLING DETAIL**



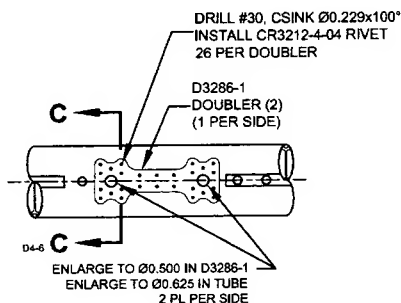
**D2650-5 ASSEMBLY/FINISHING DETAIL**

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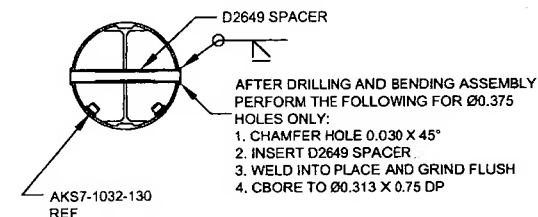
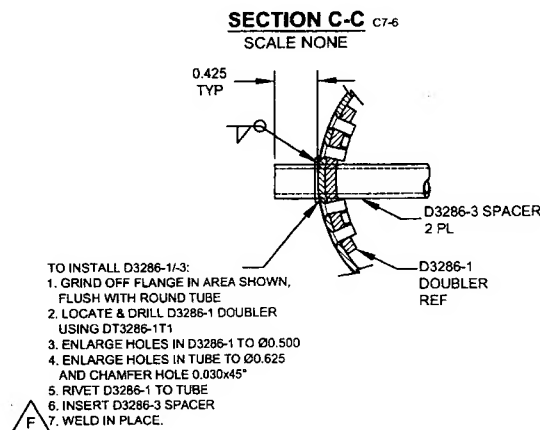




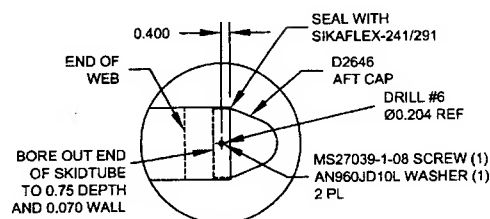
**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5



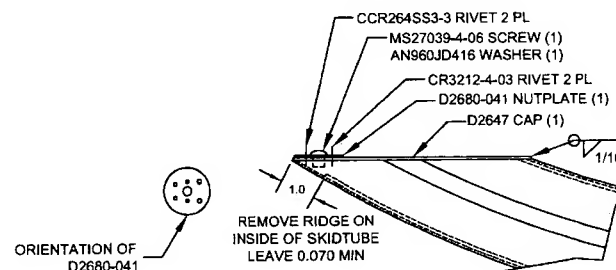
**DETAIL B**  
SCALE 2X  
C3-2  
C3-3



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

**DETAIL F NOTES:**  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS NECESSARY)  
4. WELD D2647 IN PLACE PER DART QSI 004  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE IN PLACE  
NOTE: MASK THREADS IN D2680-041 PRIOR  
TO FINISH

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